

Work Order ID 71489

Tuesday, July 05, 2011 8:41:16 AM



Page 1

Item ID: D412-698-023

Accept



Setup Start



Revision ID:

Item Name: Automatic Door Opener, LH/RH

Stop



Start Date: 7/5/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/19/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: CMF Date: 11-07-05

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D412-698	Rev E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-698-023 CHG002

W 11 07 21 (4)
JB for BG 11-7-20

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

JB 11/07/20

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

W 11 07 21 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D412-698-023

Accept



Setup Start



Revision ID:

Stop



Item Name: Automatic Door Opener, LH/RH

Start Date: 7/5/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/19/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00				11/7/21		5	(4x)
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-023 Location: <u>10A</u> PPP Rev: _____								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/7/22

ME
11-09-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 71489

Parent Item: D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 7/5/2011

Required Date: 7/19/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-07-12 JLM
IPP rev B ecn 1207 08.07.03 EC verified by:LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD516L Washer	NAS1149D0516L	Purchased	No			120	Each	12.0000	12	8	114797 JB		
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
					ST347			12					
					112466			12					
D3552-11 Door Prop		Manufactured	No			120	Each	12.0000	12	4	JB		
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
					ST272			12					
					68791			12					
D3594-043 Floor Doubler Assembly, LH		Manufactured	No			120	Each	13.0000	12	4	JB		
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
					ST234B			13					
					67012			13					
D3594-044 Floor Doubler Assembly, RH		Manufactured	No			120	Each	11.0000	12	4	JB 11/07/20		
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
					ST234B			11					
					68387			11					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 71489

Parent Item: D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 7/5/2011

Required Date: 7/19/2011

Start Qty: 4.00

Required Qty: 4.00

D3594-5

Manufactured No

120

Each

5.0000

Door Doubler

Location

Loc Qty

Loc Code

ST234A

5

66651

5

120

Each

15.0000

D3622-1

Manufactured No

Ball Stud

Location

Loc Qty

Loc Code

ST070

15

67284

15

120

Each

2,452.000

MS20426AD4-4

Purchased No

Rivet

Location

Loc Qty

Loc Code

ST317

2452

116188

2452

120

Each

97.0000

MS21073L5

Purchased No

nut plate

Location

Loc Qty

Loc Code

ST302

97

117395

97

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW